

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008770**Date Inspected:** 01-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	TOWER Components				

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Sandeep Kumar was present during the times noted above for observations relative to the work being performed.

OUTSIDE YARD**Magnetic Particle Testing**

This QA inspector performed random verification MT of the area previously tested and accepted by ZPMC Quality Control personnel. The members are identified as Tower Components. The component details are as follows:

North shaft (Lift-1)

Fit lugs to stiffeners / diaphragm / skin

This QA Inspector observed the following work not in compliance:

During random verification Magnetic Particle Testing (MT) for the North shaft (Lift-1) fit lugs to stiffeners / diaphragm / skin, observed a total Five (5) Transverse linear indications. These areas were previously tested and accepted by ZPMC Quality Control personnel.

The affected weld designations are as follows:

NSD1-A112A/H-02 (Diaphragm 9M) - One (1) Transverse linear indication

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NSD1-A112A/H-43 (Diaphragm 9M) - One (1) Transverse linear indication
NSD1-A112A/H-46 (Diaphragm 9M) - One (1) Transverse linear indication
NSD1-A112A/H-48 (Diaphragm 9M) - One (1) Transverse linear indication
NSD1-A112B/H-161 (Diaphragm 13M) - One (1) Transverse linear indication

For Further details please see the incident report: - 040120F4_TL-15_B227_09-01-09_ (MT) Transverse Indications (North Lift-1).

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
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Reviewed By:	Prue,Erik	QA Reviewer
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